Dart Aerospace Ltd. Tuesday, 7/17/2007 2:00:04 PM Kim Johnston User **Process Sheet** : CLEVIS **Drawing Name** Customer : CU-DAR001 Dart Helicopters Services Job Number : 33585 : 10104 **Estimate Number** IA : D2012107 P.O. Number **Part Number** D2012-107 REV. C : 7/17/2007 **Drawing Number** This Issue : N/A Prsht Rev. : NC Project Number : SMALL /MED FAB First Issue Type **Drawing Revision** : 32551 Previous Run Material Each **Due Date** Qty: 100 Um: Written By Checked & Approved By : Est: D 61.11.08 Re-format, Drawing to Rev. C SM Comment Est Rev:E Now on Waterjet 06-06-13 JLM **Additional Product** Job Number: Description: Seq. #: **Machine Or Operation:** M304S16GA 304/316 .063 Sheet 1.0 Comment: Qty.: Total: 1.4595 sf(s) 0.0146 sf(s)/Unit 304/316 .063 Sheet (M304S063) M103961 FLOW WATER JET 2.0 WATER JET Comment: FLOW WATER JET 1-Cut as per Dwg D2012-107 Dwg Rev:_ Prog Rev: 2-Deburr if necessary INSPECT PARTS AS THEY COME OFF MACHIN 3.0 QC2 Comment: INSPEC PARTS AS THEY COME OFF MACHINE SAO SECOND CHECK 4.0 QC8

NC BRAKE

Comment: SECOND CHECK

BRAKE NC 5.0



Comment: NC BRAKE Form on press using DT8242 as per Dwg D2012-107



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES							
DATE STEP		PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No: _	PAR #:	Fault Category:	NCR: Yes (No) DQA	:D Date: 07/08/10
			QA: N/C Closed:	Date:

WORK ORDER NON-CONFORMANCE (NCR)						
n Approval	Anneoval					
Chief Eng	Approval QC Inspecto					

NOTE: Date & initial all entries

Tuesday, 7/17/2007 2:00:04 PM Date: Use*: Kim Johnston **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services **Drawing Name: CLEVIS** Job Number: 33585 Part Number: D2012107 Job Number: Seq. #: Description: **Machine Or Operation:** INSPECT WORK TO CURRENT STEP 6.0 QC5 Comment: INSPECT WORK TO CURRENT STEP 7.0 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 8.0 QC21 100

Comment: FINAL INSPECTION/W/O RELEASE

C207/08/10

Job Completion

Dart	: Ae	ros	pace	Ltd

W/O:		WORK ORDER CHANGES	WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No):	PAR #: Fault Category: NC	R: Yes	s No DQ	A:	Date:	

QA: N/C Closed: ____ Date: ____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section B		Varification	Approval Chief Eng	Ammoval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C		Approval QC Inspecto	
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	33585
Description: Clevis	Part Number:	D2012-107
Inspection Dwg: D2012 Rev: C		Page 1 of 1

Inspection Dwg	g: D2012 Re	v: C				Pag	e 1 of 1
	r	ST ARTICLE	г		ECKLIST otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Com	ments
0.380	+/-0.010	0.378	1		Vern		
1.325	+/-0.010	1.225			Vern		
2.649	+/-0.010	2.648			Vern		
0.380	+/-0.010	0.379			Vern		
0.750	+/-0.010	0.749	1		Vern		
R0.354	+/-0.010	RO. 354	レ		Vern		
Ø0.257	+0.006/-0.001	Ø0.760	/		Vern		
0.063	+/-0.010	0.057	/		Vern		
						_	
Measured by:	540	Audited b	v:\ \(\sum_{\color} \)		Prototype App	roval	N/A
	SAD	Dat			Trototype App	Date:	N/A
Date:	07/07/20	Dat	· OHU	170		Date:	IN/A

Rev	Date	Change	Revised by	Approved
Α	07.02.02	New Issue	KJ/JLM OK	

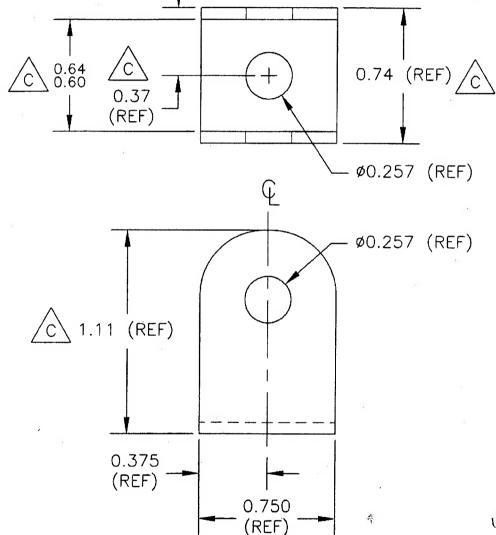




	DESIGN BW	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CANAD	
)	CHECKED	APPROVED	DRAWING NO.	REV. C
	.90	1	D2012-107	SHEET 1 OF 2
	DATE		TITLE	SCALE
	99.12.20		CLEVIS	2:1
	Α	94.10.27	NEW ISSUE	

RELEASED (COLOUTED PS)

99.12.20		CLEVIS	2:1
Α	94.10.27	NEW ISSUE	÷
В	99.04.30	ADD FLAT PATTERN	
С	99.12.20	0.74 WAS 0.680	



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MATERIAL: AISI 304/316 SS 0.063 THICK

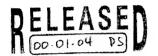
USE 0.032 BEND RADIUS

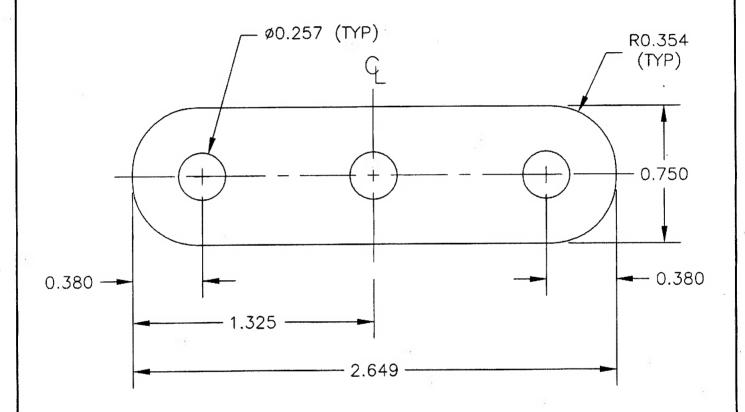
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES



DESIGN BW	DRAWN BY	•	OSPACE LTD ontario, canada
CHECKED.	APPROVED H	DRAWING NO. D2012-107	REV. C SHEET 2 OF 2
DATE.	•	TITLE	SCALE
99.12.20		CLEVIS	2:1





D2012-107 FLAT PATTERN

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ALL DIMENSIONS ARE IN INCHES